



Technical Service Bulletin 04T05
TURNTABLE CEMENT FORM INSTALLATION
For 6ft x 10ft Turntables

1. **General.** These instructions apply to installation of form boards on a standard or tilting 6 ft x 10 ft turntable. The principles apply to other types of tabletops.
2. **Tools**
 - a. Tools: Hammer, portable circular saw, tape measure, square, pencil, staple gun, screw gun (optional), 2 C-clamps with minimum 3-1/8" jaw, and 4 C-clamps with minimum 4-1/2" jaw (clamps are recommended but optional).
3. **Supplies.** These supplies are calculated for a 6'x10' standard or tilting turntable with a form height resulting in a 4" thick cement top (2-1/4" above the steel top and 1-3/4" below the steel top).
 - a. 2x4x8ft 4 each
 - b. 2x8x8ft 2 each
 - c. 2x8x10ft 2 each
 - d. 1/2"x4x8 plywood, 2 each
 - e. 20d nails or 2.5" deck screws 2 lb
 - f. 1" common nails 1 lb
 - g. 6'x12' 4mil poly film 1 sheet
 - h. 1/4" staples 1 box
4. **Side Forms**
 - a. Cut 2 side form boards 2x8x119-7/8" and 2 end form boards 2x8x75".
 - b. Cut 12 plywood pieces roughly 2" wide x 6" long. (Cut these pieces after cutting the plywood floorboards below.)
 - c. Scribe a line along one side of each of the above 2x8s (4a & 4b) 6" from one edge.
 - d. Using 1" nails, attach the long edge of the plywood pieces to the line on the 6" side 2" in from each end and centered at 40" and 80" on the long sideboards. These strips will serve to locate the top of the side forms 2-1/4" above the tabletop.
 - e. On the tilting turntable only, remove the stop pipes and notch one of the long side boards to fit around each of the three stop pipe frames.
 - f. Set the side form boards in place around the perimeter of the table with the plywood strips facing in and resting on the bottom lip of the steel frame. Nail/screw the ends to each other at the four corners.
 - g. Use C-clamps or wood pieces to clamp the sideboards against the steel frame to prevent bulging out during the cement pour. Use 1 clamp at the center of each end board and 2 clamps roughly centered at 40" and 80" for each of the two side boards.
5. **Floor Forms**
 - a. Cut 30 pieces 2x4x12.0" and lay 6 pieces each down flat between the H beams of the tabletop. Locate one at each end and the others evenly spaced in between. These will fit loose so they can be removed after cure.
 - b. Cut 10 panels 1/2"x6.75"x8ft and lay down pairs side by side on the above 2x4x12s and toward one end of the table.

- c. Cut 10 panels 1/2"x6.75"x20.5". Lay them down on the 2x4x12s tandem to the above 8ft panels to complete the floor.
 - d. Move the closest 2x4x12 under the joint between the long and short floor panels to support the joint.
 - e. Cut 5 strips of 4mil poly 15.5"x118.5". Lay the strips on the floor panels and run the excess up 1" all around against the steel sides to seal the floor. Staple in place to the panels.
6. **Pour cement top** per separate instructions.